

5227414



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6103-003
Job Sheet 201631

DAS
13
9-89



Part No: D6103-003

Job Qty: 20 pcs

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/31/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs	10/31/19	10/31/19	0.00	0.00	Purchasing - 1		DAS 81 9-89
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	20 pcs	10/31/19	10/31/19	0.00	0.00	Packaging 2 - 1 - B4B		OCT 28 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S227414



Part: D6103 - 003

Job No: 201631

Serial No/Batch: S227414

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/28/19

Plex 10/8/19 8:02 AM Dart.Lavoie.Chantal

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 18	20 pcs	10/31/19	0.00 0.00	QC 18 - 12	
				QC 18 - 14	
				QC 18 - 22	
				QC 18 - 25	
				QC 18 - 48	
				QC 18 - 58	
				QC 18 - 61	
				QC 18 - 9	
				QC 18 - 81	
130 Packaging 3-1 - Stock - B4B	20 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	20 pcs	10/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

B4B
21
9-30

OCT 2 2019

Part Op 100 - (Purchasing) Issue P/O: _____ a) Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Descriptions: Tolerance on all dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached

120 - QC18 (QC18 In-Coming Inspection Material)

130 - (Identify as per dwg & Stock Location: _____) LOCATION: MAT043

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	20 pcs (1 ea)	100-Purchasing	S226780 Vm.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	20	0	0

Part Specifications

Specifications could not be found.

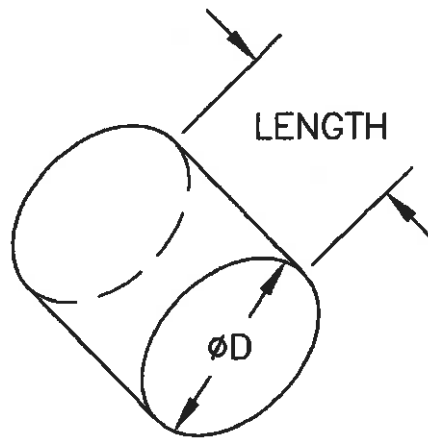
Plex 10/8/19 8:02 AM Dart.Lavoie.Chantal



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



Line 4
D6103-003

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044728



Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: POHB044728

PO Date: 10/8/19

Due Date: 10/31/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavole, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavole@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

OCT 10 2019

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	201627	D6101-001P	72746	7075-T7351 2X6X6.25 AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	10/31/19	40 pcs	40 pcs	40 pcs	\$29.57/pcs	\$1,182.80
									40 pcs VM			
												OCT 27 2019
2	201628	D6101-003P	72742	7075-T7351 2X6.25X7.875 : Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	10/31/19	20 pcs	20 pcs	20 pcs	\$38.82/pcs	\$776.40
									20 pcs VM			
												OCT 27 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044728



Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
3	201629	D6101-007P	72743	7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075-T7351 (QQ-A-250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	10/31/19	20 pcs	0 pcs 20 pcs vm	20 pcs	\$61.72/pcs	\$1,234.40
											OCT 27 2019	
4	201631	D6103-003P		Round Alum Billet : Various STC's AS PER DWG D6103 REV. B MATERIAL: 7075-T7351 AS PER QQ-A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	10/31/19	20 pcs	0 pcs 20 pcs vm	20 pcs	\$60.40/pcs	\$1,208.00
											OCT 27 2019	
Grand Total:											\$4,401.60	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/8/19 2:48 PM Dart.Lavoie.Chantal



A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:4022810

Ship From:		Sold To:	Ship To:	Deliver To:
A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped	Inco Terms	Freight Terms	Carrier	BOL No
23-OCT-19	Origin HAWKESBURY ON CAN	Prepaid	LOCAL_FLEET	4022810-5

Shipment Details	Final Destination Branch - TOR
------------------	--------------------------------

Order No	Line No	Item No	Description
5621107	4	8808.MO	3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9
Purchase Order No	Part Number	Ordered Qty	Invoice Qty
POHB044728	YOUR ITEM NUMBER: D6103-003	22.00 PCS	22.00 PCS
Details			
ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS			
Delivery No.	Mill	Heat Number	Mech Id
122926381	KAISER ALUMINUM	 202439631	22
		Width (IN)	Length (IN)
			266.7582

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to
These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified.
They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form
or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.
Date Printed: 23-OCT-2019 03:42:47 PM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

06.17.13

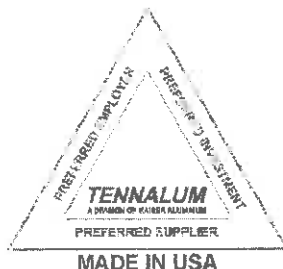
Date:

Name: *[Signature]*



KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
309 Industrial Drive
Jackson, TN 38301
731-423-2811



CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER: 507773-1		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 730762	LINE ITEM: 1	SHIP DATE: 05/28/2019	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 2244 lbs.	QUANTITY: 16 pcs.	B/L NUMBER: 43785	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3800 Enterprise Drive Janesville, WI 53546 USA			SOLD TO: A M Castle & Co 1420 Kensington Road Suite 220 Oak Brook, IL 60523 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20243963	71.0	59.9	15.0	39.2

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Zr	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.08	0.25	1.3	0.04	2.7	0.19	5.7	0.03	0.01			20243963
Max:	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	0.15	
Min			1.2		2.1	0.18	5.1					

Specifications

Standard: ISO 9001, ASTM B211-19, AMS 4124, AMS-QQ-A-225/9A Non-Standard: A97075_11_R17

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 265861

Kaiser Order Number: 730762

Line Item: 1

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6103-003
 DATE: OCT 27 2019

PO / BATCH NO.: DOHB044728/
5226780

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 22 pcs
 QUANTITY INSPECTED: 22 pcs
 QUANTITY REJECTED: -

THICKNESS ORDERED: 3.5" Ø
 THICKNESS RECEIVED: 3.5" Ø
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	AMS-QQ-A-225/9A
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	HT: 20843963
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____ DATE: <u>OCT 27 2019</u>	DAS 81 9-89	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in